

Date: Monday, 15/06/2009 4:20:10 PM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HAT BIN 206 A/B, IVORY |
| Job Number : 48592A | |
| Estimate Number : 13592 | |
| P.O. Number : | Part Number : D38241KIV |
| This Issue : 15/06/2009 S.O. No. : | Drawing Number : D3824-1 |
| Prsht Rev. : NC | Project Number : |
| First Issue : / / Type : THERMOFORMING | Drawing Revision : <i>BB</i> |
| Previous Run : 45747 | Material : MKYD6185S125P362015 |
| Written By : | Due Date : 22/06/2009 Qty: <i>2</i> Um: Each |
| Checked & Approved By : <i>J. Dawson</i> | |
| Comment : Est. A New Issue 08/09/17 DL Rev. B Dwg. Update. 09/02/09 DL verified by:DD Est. Rev. C Add Colour Code 09/06/02 DL | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|---------------------|------------------|
| 1.0 | MKYD6185S125P362015 | 6185 KYDEX .125" |
|-----|---------------------|------------------|



Comment: Qty.: 11.4442 sf(s)/Unit Total : 34.3325 sf(s)
 6185 Kydex .125" Ivory *M110426*

| | | |
|-----|----------------|------------------------------|
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|

**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/06/18

| | | |
|-----|----------------|------------------------------|
| 3.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|

**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

DL 09/06/18

| | | |
|-----|---------------|-----------------------|
| 4.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3824-1 and folio FTA 033 using tool DT 9405

Dwg. Rev. *BC*
 Folio Rev. *B*

BB 09/06/18 (X2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 15/06/2009 4:20:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN 206 A/B, IVORY

Job Number: 48592A

Part Number: D38241KIV

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/06/18 (Y2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DL 09/06/18

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 09/06/18

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DL 09/06/18

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/18 (X2)

~~09/06/18~~

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

HELD IN THERMO FOR PACKAGING

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



MF
09-06-23

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

| | | |
|--------------------|--------|-------------------------|
| DART AEROSPACE LTD | | Work Order: 48592A |
| Description: | | Part Number: D3824-1R10 |
| Inspection Dwg: | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than <u>N/A</u> " | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

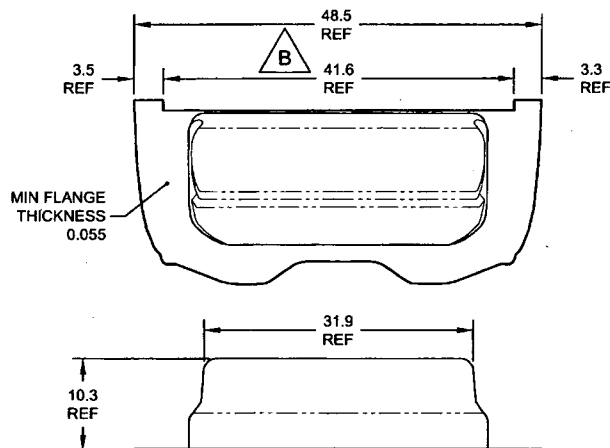
Measured by: LM Date: 09/06/18

TRIMMING SECTION

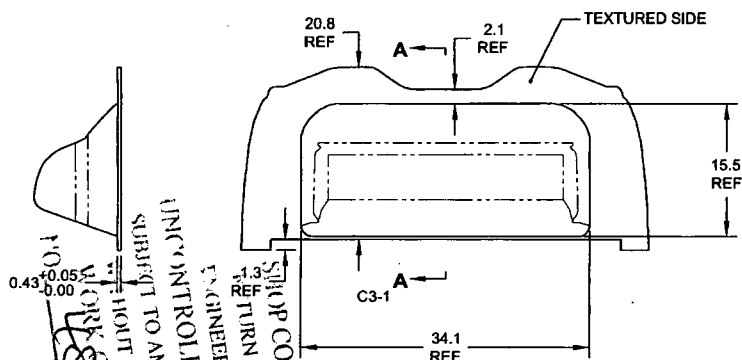
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-------------|------------------|--------|--------|----------------------|----------|
| 0.43" | $\pm 0.05"$ | 0.427 | ✓ | | | |
| 48.5" | Ref | 48.5 | ✓ | | | |
| 34.1" | Ref | 34.0 | ✓ | | | |
| 41.6" | Ref | 41.6 | ✓ | | | |
| 0.055" | N/A | 0.110" | ✓ | | | |
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Measured by: DM Date: 09.06/18
 Audited by: S Date: 09/06/18
 Prototype Approval: N/A Date: N/A

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |



SECTION A-A
SCALE 2X



D3824-1 HAT BIN
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD

| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3824-1KIV | KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3824-1KGY | KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| C | ADD STEEL GRAY COLOUR OPTION. ADD IVORY P/N'S D3824-1KIV, D3824-3KIV AND ADD STEEL GRAY P/N'S D3824-1KGY, D3824-3KGY (ZN A5-1, A5-2) | PH | 09.05.05 |
|------------|---|----|----------|
| B | 0.125 THICK WAS 0.080 (ZN A7-1, A7-2) REASON: TO IMPROVE DURABILITY; MODIFY WIDTH TO ALLOW FOR BETTER FIT WITH A/C (ZN D6-1, D6-2) | PH | 09.02.19 |
| A | NEW ISSUE | PH | 08.10.01 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.05.05 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3824 SHEET 1 OF 2
TITLE SCALE
HAT BIN (BELL 206 A/B) NTS

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RELEASED
09/05/2008

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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